

Work Order ID 85568

June-11-12 10:05:02 AM

85568

Page 1

Item ID: D6101-015

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle Billet

Start Date: 11/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 12/06/12

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D6101

B

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O:

17190

- a) Description: Alluminum billet
- b) 9.450" x 6.250" x 2.50" thick (+0.030 / -0.000)
- c) Tolerance on all dimensions are +0.030/-0.000"
- d) Grain direction along 9.450" length
- e) Material: 7075-T7351 (QQ-A-250/12)
- f) Material certification required

CL 12/06/12 10

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

10x CL/SP
12-6-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85568

June-11-12 10:05:02 AM

85568

Page 2

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Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D6101

mk 12/06/15 - 10 15

130

Identify as per dwg & Stock Location: MAT45 0.00***130***

Packaging

Memo

0.00

Packaging

mk 12/06/15 - 10 15

140

QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

Quality Control

12/6/18 J

MF 12-06-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

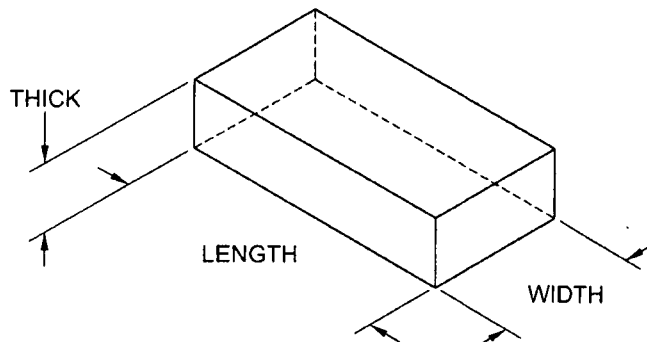
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 055108445
 12/06/11

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

RELEASED
 09/07/15/W

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	COPYRIGHT © 2001 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

B I L L O F L A D I N G

No: VIM 376102

Ship From:
THYSSENKRUPP MATERIAUX NA
4700 BOIS FRANC
ST. LAURENT, QC H4S 1A7
Tel: 514-337-0161 Fax: 514-745-2968

Ship Date 15Jun12 at 16:37 From VFW
Probill
Via O/T
FOB CONCORD
Frt PREPAID
Route 0- 0 Manifest
Vhcle Trailer
Slp STAN IVERS (905-532-1350)
Sold To: (20115)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7

Ship To: (1)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
Tel: 613-632-9577 Fax: 613-632-1053

B I L L O F L A D I N G

1) Our Order PEC-460625- 1 Your PO # 17190
Part # D6101-015 Rel #

ALUMINUM PLATE 7075T7351

2.50" THICK X 6.2500" X 9.4500"

GRAIN DIRECTION TOWARD THE 9.450 DIRECTION**

	Heat Number	Tag No	Quantity	PCS	Net Wt	Gr LB
AFID#1-REC FL	572789A6	257404	4.10 SFT	10	165	17

	Tags	PCS	Net Wt	Gr LB
TOTAL:	1	10	165	17

ADD ON TO 460623*****

MILL TEST REPORTS, PACKING SLIPS ARE TO SENT
WITH MATERIAL AND FAXED TO THE CUSTOMER PRIOR
TO SHIPPING.

ATTN: CHANTAL/LINDA

** ALL PACKING SLIPS MUST HAVE THE HEAT NUMBER **

** REFERENCED ON IT **

***UNE SURCHARGE D'ENERGIE DE \$25.00

SERA AJOUTEE A CHAQUE COMMANDE.***

***PLEASE NOTE A \$25.00 ENERGY SURCHARGE WILL BE
ADDED TO EVERY ORDER.***

*** POUR VOS BESOINS D'ACIER INOXYDABLE,

CONTACTEZ-NOUS. NOUS L'AVONS! TEL. 800-926-2600*

** FOR ALL YOUR STAINLESS STEEL NEEDS, CALL US.

Page: 1Continued

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE
RAPPORTÉES IMMÉDIATEMENT.

ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY

RETOUR DE MARCHANDISES AVEC NOTRE NUMERO D'APPROBATION SEULEMENT.
MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER.

B I L L O F L A D I N G

Ship From:
THYSSENKRUPP MATERIAUX NA
4700 BOIS FRANC
ST. LAURENT, QC H4S 1A7
Tel: 514-337-0161 Fax: 514-745-2968

No: VIM 376102.
Ship Date 15Jun12 at 16:37 From VFW
Probill
Via O/T
FOB CONCORD
Frt PREPAID
Route 0- 0 Manifest
Vhcle Trailer
Slp STAN IVERS (905-532-1350)
Sold To: (20115)
DART AEROSPACE

Ship To: (1)
DART AEROSPACE

B I L L O F L A D I N G

*** WE HAVE IT! *** TEL. 800-926-2600 ***

Page: 2 Last

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE
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MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER.

THYSSENKRUPP MATERIALS NA

PART AEROSPACE

ALUMINUM PLATE 7075T7351
60" THICK X 6.2500" X 9.4500"
PART NO. D6101-015

PO/Rel 17190

Nous certifions que le document reproduit ici est
une copie conforme du rapport fourni par le
producteur du matériel ou les données résultant de

Certificate of Mill Test Results

BL VIM-376102-001

14Jun12

L'analyse faite par un laboratoire qualifié.
SIGNÉ PAR: *[Signature]*

KAISER
ALUMINUM
FABRICATED PRODUCTS

Best in Class

CERTIFIED TEST REPORT

<http://Online.KaiserAluminum.com>

Kaiser Aluminum
Trentwood Works
Spokane, WA 99215-5108
(800) 367-2586

CUSTOMER PO NUMBER: 5400124073-40		WORK PACKAGE:		CUSTOMER PART NUMBER: ALFLR00249-48.5		PRODUCT DESCRIPTION: Sawed Plate	
KAISER ORDER NUMBER: 1127840	LINE ITEM: 4	SHIP DATE: 02/22/2012		ALLOY: 7075	CLAD: BARE	TEMPER: T7351	
WEIGHT SHIPPED: 3562 LB	QUANTITY: 2 PCS EST.	S/L NUMBER: 2035908		GAUGE: 2.5000 IN	WIDTH: 48.500 IN	LENGTH: 144.500 IN	
SHIP TO: COPPER & BRASS SALES 5 STERLING DRIVE WALLINGFORD, CT 06492 US				SOLD TO: COPPER & BRASS SALES ATTN: ACCOUNTS PAYABLE P.O. Box 5116 SOUTHFIELD, MI 48086 US			

MHU 1563799: LOT 572789A6: 2 pieces

Certified Specifications

AMS 4078/RevC AMS-QQ-A 250/12 AMS-STD-2154/Rev98 ASTM B 209/Rev10 ASTM B 594/Rev09
BAC 5439/RevH BSS 7055/RevA CMMP C25/RevU CSTI 006/RevD DSI 713/RevA BAC 713/RevA
MS1011/RevE GAMPs 9101/RevB GSS161C0/RevG/And1 MMS 159/RevC USS 2121/RevL VIM 376102-001

Test Code: 4297

Test Results:

LOT: 572789A6 CAST: 449 DROP: 16 INGOT: 4

Melted in USA

(ASTM E8/B557)

(EN 2002-1)

Tensile: Temper

Dir/#Tests

T7351

LT / 02 (Min:Max)

Ultimate KSI (MPa)

70.1 : 71.1

(483 : 490)

Yield KSI (MPa)

58.8 : 60.2

(405 : 415)

Elongation %

11.7 : 11.7

(ASTM E1004)

(EN 2004-1)

Conductivity %IACS:

41.9 Min

42.2 Max

(MS/M):

24.3 Min

24.5 Max

(ASTM E1251)

Chemistry:

Actual	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
0.07	0.17	1.5	0.02	2.4	0.19	5.9	0.02	0.01	0.01	TOT	0.05

Chemistry:

7075	MIN	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	0.00	MAX	0.05
0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15	

Aluminum Remainder

12/06/15



Plant Site: 1127840

Kaiser Order Number: 1127840

Line Item: 4

Page 1 of 2

From: Copper and Brass Sales

Cust: VIMETAL PECKOVER

Part:

Wgt: 378.083 LB

Del: 2401782928

PO: VIM-63328

Date: 03/30/2012

James K. Baber

THYSSENKRUPP MATERIALS NA

DART AEROSPACE

ALUMINUM PLATE 7075T7351
.150" THICK X 6.2500" X 9.4500"
PART NO. D6101-015

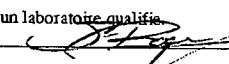
PO/Rel 17190

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producteur du matériel ou les données résultant de

Certificate of Mill Test Results

BL VIM-376102-001

15Jun12

L'analyse faite par un laboratoire qualifié
SIGNE PAR: 

Pg 2/2

KAISER
ALUMINUM
FABRICATED PRODUCTS

Kaiser Aluminum
Trentwood Works
Spokane, WA 99215-5108
(800) 367-2586

CERTIFIED TEST REPORT

<http://Online.KaiserAluminum.com>


Miscellaneous Notes

Metal represented by this test report was 100% immersion ultrasonically tested from one side and meets the Class A and Class B requirements of all specifications referenced on this test report.

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC (Kaiser) hereby certifies that metal shipped under this order was melted in the United States of America or a qualifying country per DFARS 225.972-1(a), was manufactured in the United States of America, and meets the requirements of DFARS 222.277 for domestic content. This material has been inspected, tested and found in conformance with the requirements of the applicable specifications as indicated herein. For material thicknesses outside specification limits, mechanical properties are as shown herein and chemical composition meets specification requirements. All metal which is solution heat treated complies with AMS 2772. Any warranty is limited to that shown on Kaiser's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of Kaiser Aluminum Fabricated Products, LLC laboratory. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law. ISO-9001:2008 certified.

MIKE KLOCKE, LABORATORIES SUPERVISOR



Page 2 of 2

From: Copper and Brass Sales

Cust: VIMETAL PECKOVER

Part:

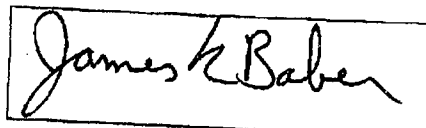
Wgt: 978.083 LB

Del: 2401782928

PO: VIM-63328

Date: 03/30/2012

Plant Serial: 4255202
Kaiser Order Number: 1127640
Line Item: 4





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO17190**

Purchase Order Date 6/12/12

PO Print Date 6/12/12

Page Number 1 of 1

Order From :

VC-COP001

THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL"A"
TORONTO, ON M5W 5V8
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	905 669 9444	Requisition Nbr	
Vendor Fax	905 738 9033	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

p to : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
6/12/12
e-mail

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D6102-013P	6061-T6 7.0x6.5x2.0	6/20/12 Yes	40.00 Each	Yours ppd	\$29.5000	\$1,180.00

Special Inst: As per DWG: D6102 Rev: D
B85430
Aluminum Billet
7.000" X 6.500" X 2.000" THICK
TOLERANCE IS +0.06/0.00
GRAIN DIRECTION ALONG 6.500"
LENGHT
MAT: 6061-T6/T6511 (QQ-A-250/11 OR
QQ-A-200/8

D6101-015P	ALUM BILLET ✓	6/20/12 Yes	10.00 Each	Yours ppd	\$77.5000	\$775.00
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Special Inst: 9.450" X 6.250" X 2.50" THICK
TOLERANCE ON DIMS ARE +0.030/-
0.000
GRAIN DIRECTION ALONG 9.450"
LENGTH
MAT: 7075-T7351 (QQ-A-250/12)

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

PO Total:

\$1,955.00

Change Nbr: 1

Change Date: 6/12/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required YES NO

Q U O T A T I O N

No: PEC ST-459995

Quoted By:
THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 9057389033

Quoted To: (20115)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7

Quoted Ship To: (1)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7

Term NET 30 DAYS/NET 30 JOURS Qtd 11Jun12 Qte Ref
Pmt PREPAID Via FOB
Tel 613-632-9577 Fax 613-632-1053 Ctc CHANTAL
Slp STAN IVERS (905-532-1350)

Q U O T A T I O N

QT No: PEC ST-459995

Test Certs: Chem-Y Phys-Y 1 Original copies with Shipment, 1 with Invoice

1 ALUMINUM PLATE 6061-T651	40 PCS	368 LBS
2.00" THICK X 6.5000" X 7.0000"		
Part No D6102-013		
GRAIN DIRECTION TOWARD 6.50 DIM		
<<<----- SPECIFICATIONS ----->>>		
Ga Tol + 0.0000 - 0.0000 Pc/Tag	40	
WthTol + 0.0630 - 0.0000 Wt/Skd		
LthTol + 0.0630 - 0.0000 Ty	Pk	
MATERIAL	40 PCS @	29.5000 EA
ENERGY & CAP SURCHG		25.0000 LOT
		1,180.00
		25.00

2 ALUMINUM PLATE 7075T7351	10 PCS	168 LBS
2.50" THICK X 6.2500" X 9.4500"		
Part No D6101-015 5-7 DAYS A.R.O		
<<<----- SPECIFICATIONS ----->>>		
Ga Tol + 0.0000 - 0.0000 Pc/Tag	10	
WthTol + 0.0630 - 0.0000 Wt/Skd		
LthTol + 0.0630 - 0.0000 Ty	Pk	
MATERIAL	10 PCS @	77.5000 EA
		775.00

MILL TEST REPORTS, PACKING SLIPS ARE TO SENT
WITH MATERIAL AND FAXED TO THE CUSTOMER PRIOR
TO SHIPPING.

ATTN: CHANTAL/LINDA

** ALL PACKING SLIPS MUST HAVE THE HEAT NUMBER **

** REFERENCED ON IT **

Price in effect at time of shipment.

Price based on receipt of total order.

All weights are theoretical.

All orders are subject to credit approval.

**** TEL. 800-926-2600 ****

*** CUSTOMER PICK-UP HOURS ***

*** 9:00 AM TO 4:00 PM ***

Q U O T A T I O N

No: PEC ST-459995

Quoted By:
 THYSSENKRUPP MATERIALS NA
 2821 LANGSTAFF ROAD
 CONCORD, ONTARIO L4K 5C6
 Tel: 905 669 9444 Fax: 9057389033

Quoted To: (20115)
 DART AEROSPACE

Quoted Ship To: (1)
 DART AEROSPACE

Q U O T A T I O N

QT No: PEC ST-459995

 * WE STOCK STAINLESS STEEL!!!! *
 * PLEASE LET US QUOTE YOUR NEXT REQUIREMENT *

 ***PLEASE NOTE A \$25.00 ENERGY SURCHARGE WILL BE
 ADDED TO EVERY ORDER.***

Order Totals: 2 Items 536 LBS

Material	Processing	Freight	Other	Taxes	ORDER AMT
1,955.00			25.00	257.40	2,237.40
Taxes: ONHSTS	257.40	0.00		0.00	0.00

